

INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁵ : B32B 3/12	A1	(11) International Publication Number: WO 93/01048 (43) International Publication Date: 21 January 1993 (21.01.93)
<p>(21) International Application Number: PCT/US92/05832</p> <p>(22) International Filing Date: 10 July 1992 (10.07.92)</p> <p>(30) Priority data: 730,267 12 July 1991 (12.07.91) US</p> <p>(71) Applicant: HEXCEL CORPORATION [US/US]; 11555 Dublin Boulevard, Dublin, CA 94568-0705 (US).</p> <p>(72) Inventors: DIXON, Doyle, G. ; 1447 Marchbanks Drive, #2, Walnut Creek, CA 94598 (US). TURNER, Peter, G. ; 130 Lozoya Way, Oakley, CA 94561 (US).</p> <p>(74) Agents: OLDENKAMP, David, J. et al.; Poms, Smith, Lande & Rose, 2121 Avenue of the Stars, Suite 1400, Los Angeles, CA 90067 (US).</p>		<p>(81) Designated States: AU, BR, CA, CS, HU, JP, KR, NO, PL, RU, European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IT, LU, MC, NL, SE).</p> <p>Published With international search report.</p>
<p>(54) Title: METHOD AND APPARATUS FOR MAKING THERMALLY FUSED THERMOPLASTIC HONEYCOMB STRUCTURES</p> <div data-bbox="578 1150 1190 1724" data-label="Image"> </div> <p>(57) Abstract</p> <p>A method and apparatus for forming a honeycomb structure (22) in which a plurality of thermoplastic layers (12, 14, 16, 18 and 20) are fused together at selected locations (24). The thermoplastic layers (12, 14, 16, 18 and 20) at each of the selected locations (24) are melted together to form a welded portion which includes first and second exterior surfaces. The welding of the thermoplastic layers (12, 14, 16, 18 and 20) is controlled so that no more than one of the exterior surfaces is melted. This partial melting of one layer prevents undesirable welding to adjacent layers. An apparatus (30) for carrying out the method for welding thermoplastic honeycomb structures is also disclosed.</p>		

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AT	Austria	FI	Finland	MI	Mali
AU	Australia	FR	France	MN	Mongolia
BB	Barbados	GA	Gabon	MR	Mauritania
BE	Belgium	GB	United Kingdom	MW	Malawi
BF	Burkina Faso	GN	Guinea	NL	Netherlands
BG	Bulgaria	GR	Greece	NO	Norway
BJ	Benin	HU	Hungary	PL	Poland
BR	Brazil	IE	Ireland	RO	Romania
CA	Canada	IT	Italy	RU	Russian Federation
CF	Central African Republic	JP	Japan	SD	Sudan
CG	Congo	KP	Democratic People's Republic of Korea	SE	Sweden
CH	Switzerland	KR	Republic of Korea	SN	Senegal
CI	Côte d'Ivoire	LI	Liechtenstein	SU	Soviet Union
CM	Cameroon	LK	Sri Lanka	TD	Chad
CS	Czechoslovakia	LU	Luxembourg	TG	Togo
DE	Germany	MC	Monaco	US	United States of America
DK	Denmark	MG	Madagascar		
ES	Spain				

METHOD AND APPARATUS FOR MAKING THERMALLY
FUSED THERMOPLASTIC HONEYCOMB STRUCTURES

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates generally to methods and apparatus for manufacturing honeycomb structures.

5 More particularly, the present invention relates to an improved method and apparatus for manufacturing thermally fused honeycomb structures.

2. Description of Related Art

10 Honeycomb core materials are widely used in industry due to their light weight and unique structural characteristics. Honeycomb cores made from relatively thin gauge thermoplastic sheets are especially useful because they are lightweight and provide flexible
15 structures which can withstand high compression loads. Such honeycomb structures are commonly found in applications as diverse as aircraft components and running shoes.

There are a variety of ways to manufacture
20 honeycomb cores. One common method of manufacture is typified by U.S. Patent No. 3,660,217, issued to Kehr et al. This method entails the formation of lines of adhesive onto sheets of material arranged in a stack. The line pattern formed on each individual sheet is
25 staggered in relation to the previous sheet. Once the adhesive lines are all in place, the stack is compressed and heated, if necessary, until the adhesive has fully cured. The resulting structure is commonly referred to as a honeycomb before expansion or stack.

30 In order to form the final honeycomb structure, the stack is expanded by applying a uniform outward force to the outermost sheets of the stack. Heat is usually applied during the expansion process in order to

permanently set the thermoplastic in its final expanded honeycomb shape.

The use of adhesives to bond the honeycomb layers together is relatively simple and is acceptable for many applications. However, a variety of factors may contribute to uneven bonding which often yields less than desirable results. For example, when using heat-cured adhesives, which typically have a lower melting point than the melting point of the sheet material, the outermost sheets of the stack may receive an excess amount of heat, while the innermost sheets receive too little heat. As a consequence, uneven bonding throughout the structure may result. It is evident then, that the dissimilar adhesive material is usually the weak link in the structure, and when the stack is expanded, the weaker bond areas may come apart under the pressure of expansion and cause gaps or tears in the honeycomb structure. The present invention eliminates the weak link associated with adhesive bonding of the sheets by providing a fused bond zone formed directly in the adjoining honeycomb layers which exhibits properties substantially identical to the properties of the honeycomb material.

Another technique for manufacturing honeycomb structures involves using weld bonds in place of adhesives. In general, this procedure involves forming the stack by sequentially welding one layer of thermoplastic material to the stack at a time. It is essential that the top sheet which is being welded to the underlying stack of layers be welded only to the uppermost layer of the stack. Inadvertent welding of the underlying layers prohibits the expansion necessary to form the honeycomb structure.

In order to prevent inadvertent welding of the underlying layers, various protective inserts are placed directly beneath the weld location. These protective inserts are typically referred to as "fingers" and are

designed to prevent the top two layers which are being weld d together from sticking to the remainder of th stack. U.S. Pat. No. 4,957,577 issued to Hu bner, discloses an exemplary procedure which utilizes
5 protective fingers.

The protective fingers work well in welding processes to prevent bonding of the uppermost layers to the body of the stack. However, use of the protective fingers is undesirable in that they must be inserted
10 underneath each weld line. This is a time consuming process and, if a finger is inadvertently left out, the two uppermost layers are welded to the underlying stack. The result is a partially blocked honeycomb structure. In addition, the fingers must be removed once the stack
15 is expanded. This can present problems, especially when the lateral dimensions of the honeycomb are large.

As is apparent from the above, it would be desirable to eliminate the need for protective fingers when welding the thermoplastic layers together while
20 still providing adequate weld bonds.

SUMMARY OF THE INVENTION

In accordance with the present invention, it was discovered that honeycomb structures can be made from
25 thermoplastic materials utilizing weld bonds without using protective fingers during the welding process. The invention is based upon the discovery that welding of the thermoplastic layers together can be controlled so that only the top two layers are bonded during the
30 welding operation. It was further discovered that a strong structural weld or fusion bond could be obtained even though both layers are not completely melted during the welding process.

The present invention involves a method for forming
35 a honeycomb structure wherein a plurality of thermoplastic layers are welded together at selected locations so that the welded layers will form a

honeycomb structure when they are expanded apart. The thermoplastic layers at each of the weld locations are melted together to form a welded portion which includes first and second exterior surfaces. As a feature of the present invention, the melting of the thermoplastic layers during the welding step is controlled so that no more than one of the exterior surfaces is melted. As a result, the two layers being welded do not stick or otherwise bond to the underlying previously welded layers.

The method in accordance with the present invention provides for strong thermoplastic honeycomb bonds at weld locations without the requirement of using protective fingers during the welding process. As a feature of the present invention, it was discovered that the degree of melting can be controlled accurately by rapidly cooling the layers being welded after the desired weld penetration has been achieved. It was found that weld penetration wherein about 75% of the combined thickness of the two layers is melted provides strong structural bonding while substantially avoiding any possibility of inadvertent bonding to underlying layers.

As another feature of the present invention, an apparatus is described which provides the controlled melting necessary to carry out the method of the present invention. The apparatus is based upon conventional heating grids used to weld thermoplastic stacks which are then used to form thermoplastic honeycombs. As a feature of the present invention, a chilling plate is provided which is used to rapidly cool the stack immediately after welding. This minimizes migration of the melt zone into the underlying layers and prevents undesirable welding of the layers.

The above-described and many other features and attendant advantages of the present invention will become apparent as the invention becomes better

understood by reference to the following detailed description when considered in conjunction with the accompanying drawing.

5 BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is perspective view of a preferred stack in accordance with the present invention.

FIG. 2 is a partial side view of the stack shown in FIG. 1 after it has been expanded to form a honeycomb.

10 FIG. 3 is a detailed view of a portion of honeycomb shown in FIG. 2.

FIG. 4 is a partially schematic side view of a preferred exemplary apparatus for carrying out the method of the present invention.

15

DETAILED DESCRIPTION OF THE INVENTION

The present invention has wide application to the formation of honeycomb structures from a variety of thermoplastic materials. The invention is applicable to
20 any of the thermoplastics which may be used to form honeycomb structures. The present invention is an improvement upon existing methods for forming thermoplastic honeycomb structures wherein the various layers of the honeycomb are bonded together by fusing or
25 welding. The formation of thermoplastic honeycomb structures involves first forming a laminated structure or stack which is also referred to as a honeycomb before expansion. The various thermoplastic layers of the stack are bonded together at selected locations so that
30 when the stack layers are expanded apart, a honeycomb structure results.

A preferred exemplary stack in accordance with the present invention is shown generally at 10 in FIG. 1. A final preferred exemplary honeycomb structure after
35 expansion of the stack 10 is shown generally at 22 in FIG. 2. The stack 10 and honeycomb structure 22 in accordance with the present invention may be fabricated

utilizing any of the known thermoplastic materials which are amenable for use in honeycomb structures. Thermoplastic materials, such as polyurethane, which can be melted and fused or welded together to provide strong
5 bonds are preferred. Other suitable thermoplastics include vinyls, ABS, polypropylene and polyethylene. Also included are the engineered thermoplastics, examples of which are polyether imide, polyarylene sulfide, polyarylene ether, polyether ether ketone and
10 others.

The stack 10 shown in FIG. 1 includes five thermoplastic layers 12, 14, 16, 18 and 20. The layers are welded together at selected locations which are depicted as the stippled areas in the stack 10.
15 Referring to the two uppermost thermoplastic layers 18 and 20, the welded regions are shown by stippling at 24. The stippling 24 represents the portion of the thermoplastic layers 18 and 20 which is melted during the welding process in accordance with the present
20 invention. The melted region extends entirely through the upper layer 20 and into a substantial portion of the lower layer 18. A principal feature of the present invention is that the melted region 24 does not extend past layer 18 into the underlying layers 16, 14 and 12.

25 Referring to FIG. 2, the layers 12, 14, 16, 18 and 20 are shown after expansion into the honeycomb structure. A detailed view of one of the weld or fusion bonds between layers 18 and 20 is shown in FIG. 3. As can be seen from FIG. 3, the layers 18 and 20 are melted
30 together at a selected location to form a welded portion which includes an upper or first exterior surface 26 and a lower or second exterior surface 28. The overall thickness of the two layers 18 and 20 at the welded portion is indicated by "d" in FIG. 3. The thickness
35 "d" is the distance between the top surface 26 and the bottom surface 28 of the welded portion.

In accordance with the present invention, it is

preferred that the melting of the two thermoplastic layers 18 and 20 be controlled during the welding process so that no more than 95% of the thickness "d" is melted. Particularly preferred is a melting of approximately 75% of the thickness "d". In all cases, the melting is conducted in one direction only so that only one of the two surfaces 26 or 28 is melted. In the normal method for manufacturing stacks where layers are sequentially stacked on top of each other, the melting will progress from the top surface 26 down towards the bottom surface 28.

Although any number of welding techniques may be utilized, it is preferred that the heat be applied to upper surface 26 by way of a heated grid. The use of such heated grids is widely known in thermoplastic fusion or welding. For thermoplastics such as polyurethane, the temperature of the heated grid will be in the range of about 350-400°F. The heated grid is placed in contact with the upper surface 26 and kept there for a sufficient time to melt the layers 18 and 20 so that the melt zone progresses down to the desired depth of penetration, i.e. less than 95% of the thickness "d". The width of the heating grid lines are varied depending upon the desired width of the welded portion. Typically, heating gridlines are on the order of a few mils wide to about 0.50 inch (1.28 cm).

After the desired melt penetration is achieved, the heating grid is then removed and the layers allowed to cool. In order to rapidly arrest any further melting of the two layers and to prevent the possibility of melt migration down into underlying layers, it is preferred that a chill plate or other means for rapidly cooling the welded layers be utilized. The chill plate should be sufficiently cool to provide cooling of the welded layers to well below the thermoplastic range within no more than a few seconds after application of the chill plate. Other possible means for chilling the stack

between weld operations include chilling by contact with cooling liquids, gases or chilled solids other than a chill plate.

Although the exemplary stack 10 shown in FIG. 1 includes only 5 layers, it is preferred that stacks having on the order of up to 200 layers and even more be made in accordance with the present invention. The use of the chill plate is especially preferred when large stacks are being manufactured since the residual weld heat produced during the welding of numerous layers can contribute to overall warming of the stack which makes accurate control of welding in accordance with the present invention more difficult.

The present invention may be used to make honeycomb structures wherein the layers have thicknesses ranging from a few mills to about 0.25 inch (0.64 cm). The present invention is not well-suited for preparing stacks utilizing thermoplastic materials having thicknesses less than 0.003 inch (0.007 cm), since layers which are that thin are difficult to weld without completely melting both layers during the welding process. Thermoplastic layers having thickness greater than 0.25 inch (0.64 cm) are difficult to fuse by welding and therefore are also not preferred.

An exemplary preferred apparatus in accordance with the present invention is shown schematically at 30 in FIG. 4. The apparatus includes a framework 32 in which the stack platform 34, heating grid 36 and chill plate 38 are mounted. The stack platform 34 is mounted on rails shown generally at 40 which are designed to allow the platform 34 to be moved alternately between positions underlying the heating grid 36 and chill plate 38.

The stack platform 34 includes a telescoping table 42. The table 42 has a top surface onto which the thermoplastic layers are positioned for welding. A partially formed stack 44 is shown in position on table

42. A positioner or fence 46 is provided to ensure accurate alignment of the layers as they are sequentially added onto the stack 44 for welding. The table 42 is shown in a retracted position in FIG. 4.

5 The table 42 may be telescoped hydraulically or electrically into contact with heating grid 36. A compression grating 48 is provided to ensure that the various stack layers are uniformly pressed together during contact with heating grid 36. The compression

10 grating 48 ensures that the heating grid 36 uniformly contacts the stack layers to be welded to ensure uniform melt penetration and welding in accordance with the present invention.

A heat shield 50 is provided between the heating

15 grid 36 and chill plate 38. A control console 52 is provided which allows the operator to accurately control the temperature of heating grid 36 and other welding parameters, such as the pressure applied to the stack 44 by the compression grating 48 and heating grid 36. In

20 addition, the contact time between the heating grid 36 and stack 44 is also controlled via the console 52.

After the welding step is completed, the stack platform 34 is transported on rails 40 to a position directly under chill plate 38. The telescopic table 42

25 is then raised so that the stack 44 contacts the chill plate 38 to provide rapid cooling. The various contact times and pressure between stack 44 and chill plate 38 are also controlled by console 52. The operator of the apparatus can accurately control the degree of melting

30 by varying the various parameters of temperature, time and pressure to achieve welding in accordance with the present invention, i.e. fusion of two layers wherein only one layer is completely melted.

The parameters of heating grid temperature, heating

35 grid-stack contact time, heating grid-stack contact pressure, chill plate temperature, chill plate-stack contact pressure and chill plate-stack contact time are

varied by the apparatus operator depending upon the thermoplastic material being used, the thickness of the layers, the size of the stack and the degree of melt penetration desired. These parameters are all easily
5 determined during start-up of a production run by measuring the degree of melt penetration and adjusting the parameters to achieve the desired melt penetration in accordance with the present invention.

For a stack made from layers of flexible
10 polyurethane having thicknesses from about 0.005 inch (0.010 cm) to about 0.050 inch (0.12 cm), the following exemplary parameter ranges are preferred:

	heating grid temperature:	350-450°F.
15	heating grid line size:	0.25 in (0.64 cm)
	heating grid/stack contact time:	3 to 16 seconds
	heating grid/stack contact pressure:	50 to 105 psi
20	compression grating/stack contact pressure:	55 to 65 psi
	chill plate temperature:	50 to 65°F.
	chill plate/stack contact pressure:	50 to 100 psi
25	chill plate/stack contact time:	7 to 16 seconds

The stacks which are formed in accordance with the present invention are then expanded by any of the known
30 techniques to form the final bulk honeycomb structure. The bulk honeycomb structure may then be subjected to further fabrication steps, such as slicing into honeycomb sheets which are then sandwiched between side support layers. The expansion of stacks and further
35 fabrication of bulk honeycomb structures into final products are well-known processes which will not be described in detail.

Having thus described exemplary embodiments of the

pr sent invention, it should be noted by those skill d
in the art that the within disclosures are exemplary
only and that various other alternativ s adaptations and
modifications may be made within the scope of the
5 present invention. Accordingly, the present invention
is not limited to the specific embodiments as
illustrated herein, but is only limited by the following
claims.

What is claimed is:

1. A method for forming a honeycomb structure comprising the steps of:

welding a plurality of thermoplastic layers together at selected locations to provide a plurality of
5 welded layers which will form a honeycomb structure when said welded layers are expanded apart, wherein said thermoplastic layers at each of said selected locations are melted together to form a welded portion which includes first and second exterior surfaces and wherein
10 said melting of said thermoplastic layers together to form said welded portions is controlled so that no more than one of said exterior surfaces is melted; and
expanding said plurality of welded layers to form said honeycomb structure.

2. A method of forming a honeycomb structure according to claim 1 wherein the melting of said thermoplastic layers is controlled so that no more than
5 95 percent of the thickness of said welded portion is melted during said welding step.

3. A method for forming a honeycomb structure according to claim 2 wherein the melting of said thermoplastic layers is controlled so that approximately
5 75 percent of the thickness of said welded portion is melted during said welding step.

4. A method for forming a honeycomb structure according to claim 1 wherein the step of welding said plurality of layers together comprises the steps of:

stacking one layer on top of another to form upper
5 and lower adjacent layers;
welding the upper and lower layers together; and
repeating said stacking and welding steps to form

a plurality of welded layers which will form said honeycomb structure when said welded layers are pulled
10 apart.

5. A method for forming a honeycomb structure according claim 1 wherein said melting of said thermoplastic layers during said welding step comprises the steps of:

5 heating said thermoplastic layers at said selected locations at a sufficient temperature and for a sufficient time to melt both of said thermoplastic layers ; and

10 rapidly cooling said thermoplastic layers at said selected locations so that no more than one of said exterior surfaces is melted.

6. A honeycomb structure comprising:

a plurality of thermoplastic layers which are welded together at selected locations to provide a honeycomb structure wherein said thermoplastic layers at
5 each of said selected locations are integrally bonded together to form a welded portion which includes first and second exterior surfaces and wherein said welded portions are formed by melting no more than one of said exterior surfaces.

7. A honeycomb structure according to claim 6 wherein no more than 95 percent of the thickness of said welded portion is melted when said thermoplastic layers are integrally bonded together.

8. A honeycomb structure according to claim 7 wherein approximately 75 percent of the thickness of said welded portion is melted when said thermoplastic layers are int grally bonded together.

9. A honeycomb structure according to claim 6

wherein said welded portions are formed by the steps of:
stacking one layer on top of another to form upper
and lower adjacent layers;

- 5 welding the upper and lower layers together; and
repeating said stacking and welding steps to form
a plurality of welded layers which will form said
honeycomb structure when said welded layers are expanded
apart.

10. A honeycomb structure according to claim 9
wherein said welding portions are formed by the steps
of:

- 5 heating said thermoplastic layers at said selected
locations at a sufficient temperature and for a
sufficient time to melt both of said thermoplastic
layers ; and

rapidly cooling said thermoplastic layers at said
selected locations so that no more than one of said
10 exterior surfaces is melted.

11. In a method for making a honeycomb structure
from a plurality of layers of thermoplastic material
wherein said layers are interconnected at welded
connections formed by melting two of said layers
5 together at selected locations, the improvement
comprising controlling the melting of said layers so
that both layers are not entirely melted during
interconnection of said layers to form said welded
connections.

12. An improved method according to claim 11
wherein said melting is controlled by heating said
layers at a sufficient temperature for a sufficient time
to completely melt one layer and partially melt the
5 other layer and then rapidly cooling said layers to
prevent further melting of said layers.

13. An apparatus for making a honeycomb structure before expansion comprising:

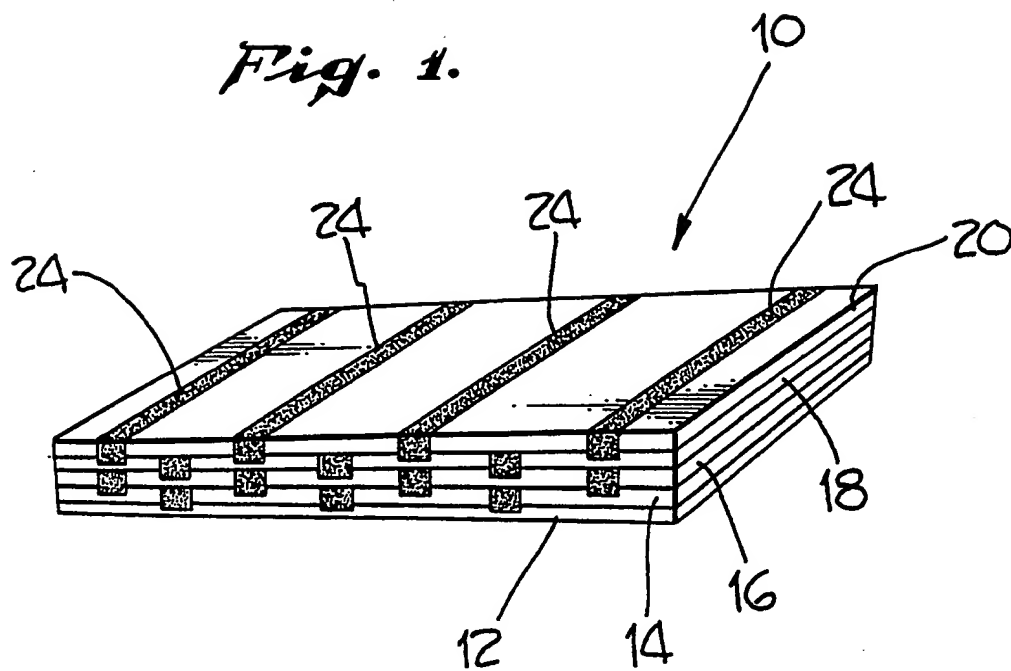
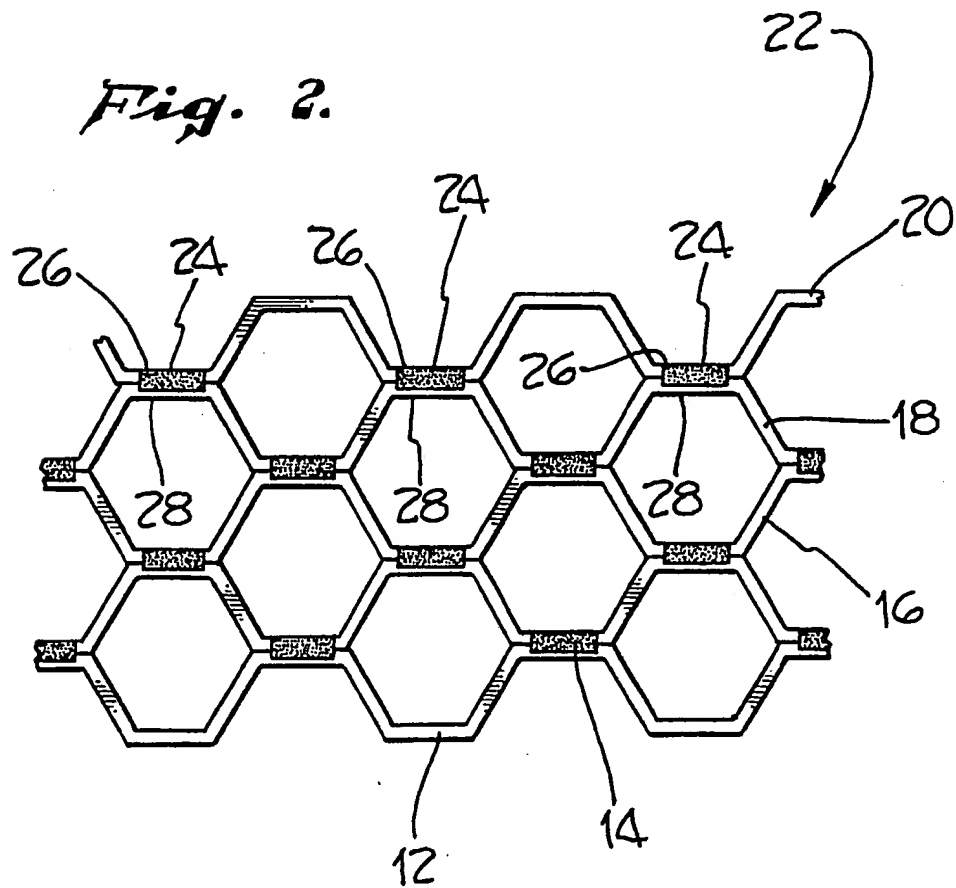
welding means for welding a plurality of thermoplastic layers together at selected location to provide a plurality of welded layers which will form a honeycomb structure when said layers are expanded apart, said welding means comprising means for melting two of said layers together at said selected locations to form a welded portion which includes first and second exterior surfaces; and

melt control means for controlling the melting of said thermoplastic layers so that no more than one of said exterior surfaces is melted.

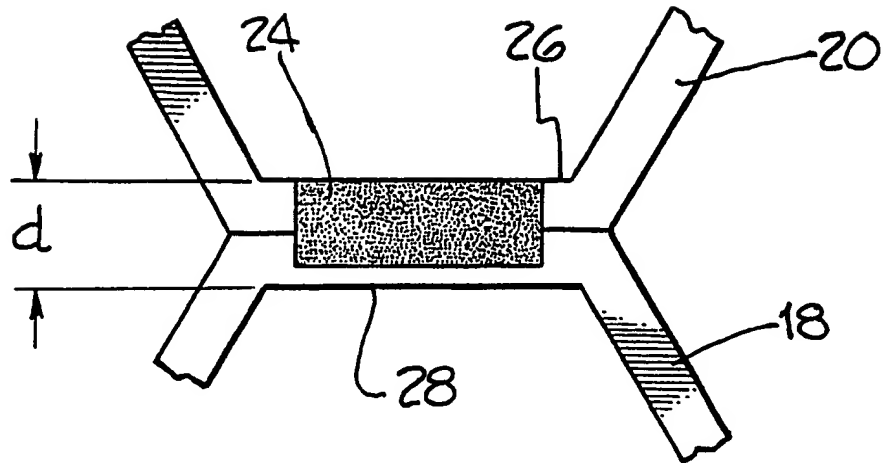
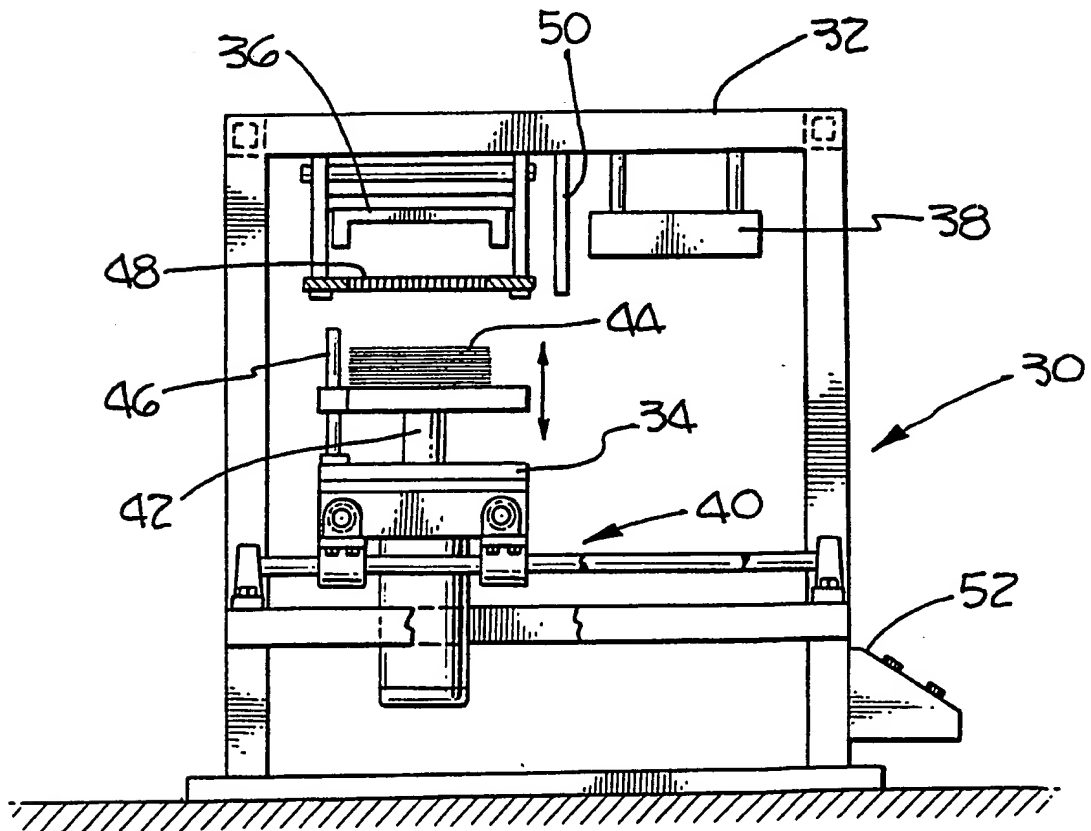
14. An apparatus for forming a honeycomb structure before expansion according to claim 13 wherein said means for melting comprises a heated grid and means for contacting said heated grid with said thermoplastic layers at said selected locations to provide heating and melting of said thermoplastic layers.

15. An apparatus for forming a honeycomb structure before expansion according to claim 13 wherein said melt control mean comprises a cooling plate and means for contacting said cooling plate with said thermoplastic layers.

1/2

Fig. 1.*Fig. 2.*

2 / 2

Fig. 3.*Fig. 4.*

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US92/05832

A. CLASSIFICATION OF SUBJECT MATTER

IPC(5) :B32B 3/12

US CL :428/116; 156/197,498

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 428/118; 156/292

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US, A,2,722,735 (BEAMISH) 08 November 1955, See entire document.	1-15
Y	US, A, 4,957,577 (HUEBNER) 18 September 1990, See entire document.	1-15
A	US, A, 4,992,132 (SCHMIDLIN ET AL.) 12 February 1991.	13-15



Further documents are listed in the continuation of Box C.



See patent family annex.

•

Special categories of cited documents:

"T"

later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"A"

document defining the general state of the art which is not considered to be part of particular relevance

"X"

document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"E"

earlier document published on or after the international filing date

"Y"

document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"L"

document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O"

document referring to an oral disclosure, use, exhibition or other means

"P"

document published prior to the international filing date but later than the priority date claimed

"G"

document member of the same patent family

Date of the actual completion of the international search

18 AUGUST 1992

Date of mailing of the international search report

28 OCT 1992

Name and mailing address of the ISA/
Commissioner of Patents and Trademarks
Box PCT
Washington, D.C. 20231

Facsimile No. NOT APPLICABLE

Authorized officer

HENRY F. EPSTEIN

Telephone No. (703) 308-2351